

**Work Order ID 72280**

Thursday, July 21, 2011 9:00:04 AM



Page 1

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005  
PRINT DWG PAGE: 41/42 OF 162

Sulos/09

CK for BG 11/09/20

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/7/228

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607  
Seal Support Gusset with Sikaflex -291  
Batch: M117516  
Exp Date: 12/01/15

B 11/08/09 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72280**

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Page 2

Item ID: D350-607-043

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Revision ID:

Stop



Item Name: Heli-Utility-Basket

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
140  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 72280**

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Page 3

Item ID: D350-607-043

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Stop



Item Name: Heli-Utility-Basket

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043 Location: _____								
170		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

CK 11/08/10

11-08-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 21, 2011 9:00:10 AM

Page 1

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket






Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM  
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as  
per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-3 		Manufactured	No			110	Each	0.0000	2	2			
Dart Logo label													
D350-607-241 		Manufactured	No			140	Each	0.0000	1	1			
Basket Clamp Assembly													
D2022-101 		Manufactured	No			110	Each	67.0000	5	5			
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		67							
				69532		7							
				69824		60							
D2221 		Manufactured	No			110	Each	1.0000	1	1			
350 Basket Base													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
				71364		1							
D2258-200 		Manufactured	No			110	Each	16.0000	1	1			
Placard 2001b													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST505		16							
				68928		4							
				71180		12							

M115056

B71292

5

8/31/08/09  
B72281

11/7/12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, July 21, 2011 9:00:10 AM

Page 2

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2332-041

Manufactured No

110 Each

6.0000

1

1



Lid Prop Assembly 6.69" long

Location

Loc Qty

Loc Code

ST512

6

70997

6

D2530

Manufactured No

110 Each

13.0000

1

1



Handle Weldment

Location

Loc Qty

Loc Code

ST506

12

70850

12

ST508

1

69318

1

D2535

Manufactured No

110 Each

107.0000

2

2



Spring

Location

Loc Qty

Loc Code

ST504

107

69495

7

71117

100

D2537

Manufactured No

110 Each

12.0000

2

2



Bushing

Location

Loc Qty

Loc Code

ST504

12

69894

12

Thursday, July 21, 2011 9:00:11 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, July 21, 2011 9:00:11 AM

Page 3

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 110 Each 618.0000 2  
Bumper

Location	Loc Qty	Loc Code
ST504	618	
46064	618	

D2989-041 Manufactured No 110 Each 1.0000 1  
Basket Lid Assembly

Location	Loc Qty	Loc Code
GA	1	
71365	1	

D2989-043 Manufactured No 110 Each 1.0000 1  
Basket Lid Assembly

Location	Loc Qty	Loc Code
GA	1	
71366	1	

AN3-16A Purchased No 110 Each 97.0000 2  
Bolt

Location	Loc Qty	Loc Code
ST352	97	
116419	1	
117441	96	

2  
1 8/5/08/09  
B 72282  
1 8/5/08/09  
B 72283  
2 11/2/22 2

Thursday, July 21, 2011 9:00:11 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 21, 2011 9:00:11 AM

Page 4

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

110

Each

1,214.000

2



Bolt

Location

Loc Qty

Loc Code

ST357

1214

117962

20

118078

594

118350

300

118351

300



2

AN4-22A

Purchased

No

110

Each

163.0000

7



Bolt

Location

Loc Qty

Loc Code

ST359

163

114784

15

116419

49

117313

99



7

AN5-17A

Purchased

No

110

Each

62.0000

4



Bolt

Location

Loc Qty

Loc Code

ST339

62

117619

18

117872

44



4

Thursday, July 21, 2011 9:00:12 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Thursday, July 21, 2011 9:00:12 AM

Page 5

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3 Purchased No  
Cherry Rivets

Location	Loc Qty	Loc Code
ST321	716	
111636	112	
117505	452	
117601	152	
WA018	133	
107939	133	

AN960JD416 NAS1149D0463J Purchased No  
Washer  
AN960JD416L NAS1149D0416J Purchased No  
Washer

Location	Loc Qty	Loc Code
FP-B	17	
110153	17	
ST298	2	
110153	2	

AN960JD516 NAS1149D0563J Purchased No  
Washer  
AN960JD8 NAS1149DN832J Purchased No  
Washer

849.0000 2 2  
14 14  
19.0000 2 2  
0.0000 4 4  
0.0000 2 2

M117591  
M1165138  
M118206  
M117316 11/7/22

Thursday, July 21, 2011 9:00:12 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, July 21, 2011 9:00:12 AM

Page 6

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket

Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4

Purchased

No

110

Each

162.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST277

162

116169

3

117460

50

117735

61

118078

48

AN970-4

Purchased

No

110

Each

311.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST342

297

117795

297

ST344

13

108377

2

115936

11

ST349

1

116900

1

MS21042L3

Purchased

No

110

Each

1,452.000

2

2



Nut

Location

Loc Qty

Loc Code

ST300

1452

117441

672

117801

400

117885

380

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 21, 2011 9:00:12 AM

Page 7

Work Order ID: 72280

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket



Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

3,712.000

9



Nut

Location

Loc Qty

Loc Code

ST300

3712

117441

1465

117601

747

117885

1500

MS21042L5

Purchased

No

110

Each

1,324.000

4



Nut

Location

Loc Qty

Loc Code

ST300

1324

116105

5

116548

135

117441

498

117591

100

117611

90

118179

496

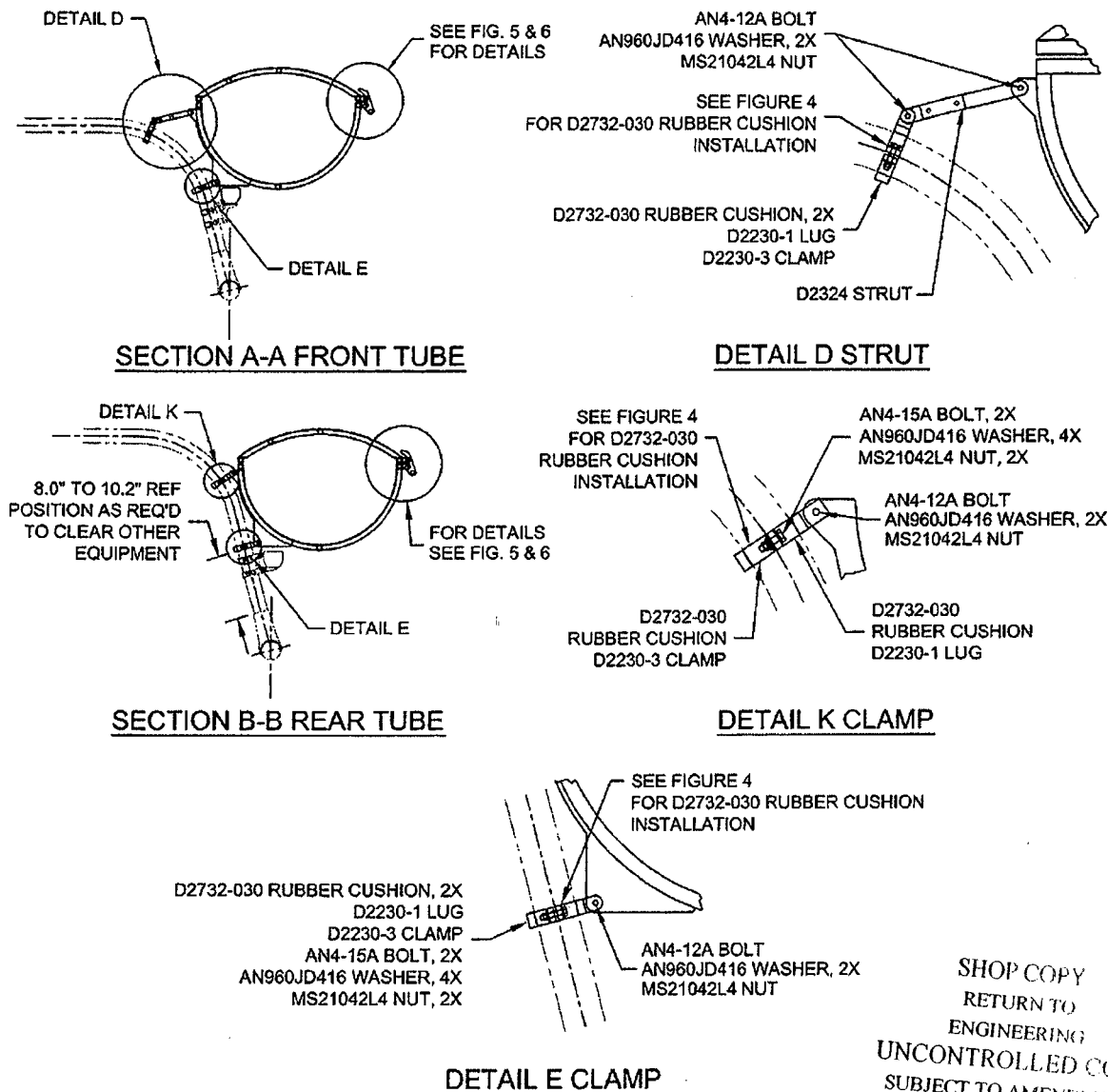
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Figure 2 - High Skid Installation**  
(LH installation shown, RH opposite)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72286

11-07-21

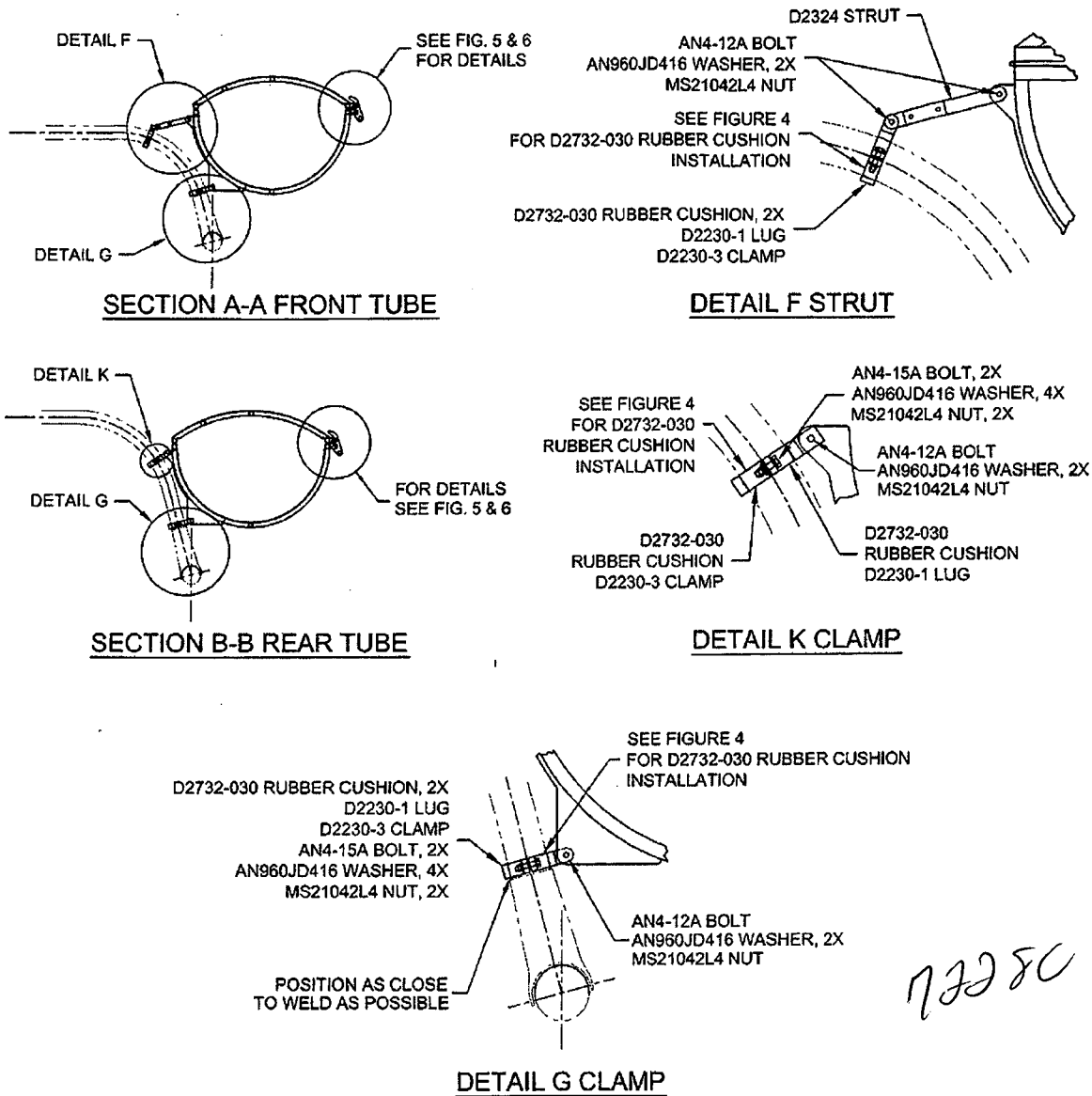
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Figure 3 – Low Skid Installation**  
(LH installation shown, RH opposite)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

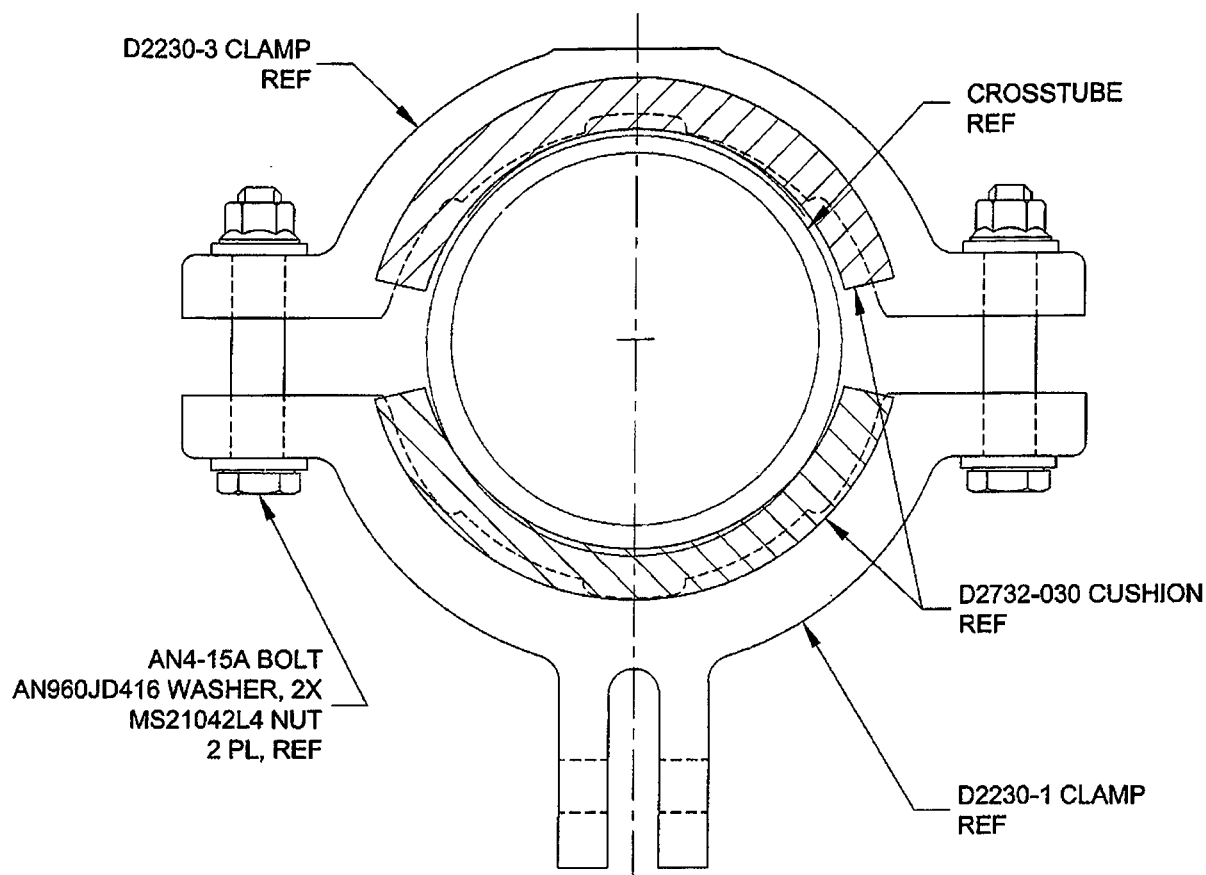
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries





72280

**Figure 4 – D2732-030 Rubber Cushion Installation**

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Revision: **A**  
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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